

Date: Tuesday, 6/12/2007 3:00:59 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEM
Job Number	: 32899		
Estimate Number	: 10857		
P.O. Number	: <u>NIA</u>	Part Number	: D34073
This Issue	: 6/12/2007 S.O. No. : <u>NIA</u>	Drawing Number	: D3407 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>NIA</u> Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 28945	Material	: <u>NIA</u>
Written By	: <u>[Signature]</u>	Due Date	: 6/19/2007
Checked & Approved By	: <u>[Signature] 07.06.12</u>	Qty:	12 Um: Each
Comment	: Est Rev: A 05.10.18 New issue KJ/EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M174R0750	Inventory
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Comment: Qty.: 0.3843 f(s)/Unit Total : 4.6116 f(s)
 Material: 17-4ph SS Round Bar Ø0.750(M17-4-R0.750)
 Identify for D3407-3
 Batch: 104965 RP 07/07/19

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA597 Rev: C & Dwg D3407 Rev: C2-Deburr RP 07/07/19

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE RP 07/07/19 (15)

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA597 and Dwg D3407

2-Deburr RP 07.07.22 (15)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ED Date: 21/07/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 6/12/2007 3:00:59 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEM

Job Number: 32899

Part Number: D34073

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

OK 07/07/22

(15)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

OK 07/07/22

(15)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Francis/Steve

07/07/23 (15)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/07/23

(15)

Job Completion



U 07/07/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	32899
Description: Stem		Part Number:	D3407-3
Inspection Dwg: D3407 Rev: C		Page 1 of 1	

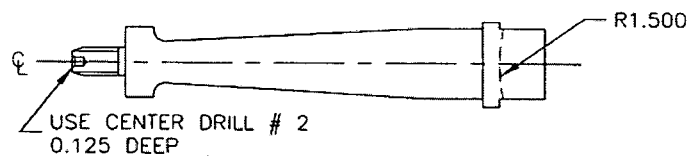
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

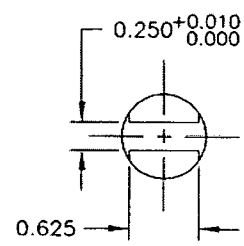
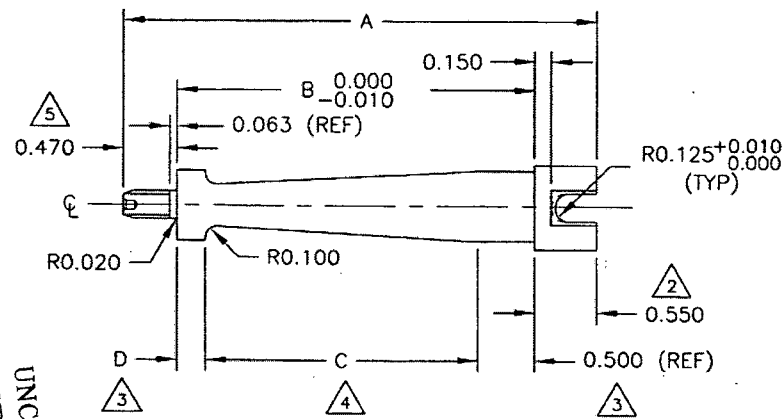
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.325	+/-0.010	4.320	✓			
3.305	+0.000/-0.010	3.298	✓			
2.555	+/-0.010	2.560	✓			
0.250	+/-0.010	0.248	✓			
0.063	+/-0.010	0.063	✓			
0.470	+/-0.010	0.463	✓			
0.500	+/-0.010	0.495	✓			
0.550	+/-0.010	0.555	✓			
Ø0.625	+0.008/-0.001	0.625	✓			
Ø0.750	+0.008/-0.001	0.751	✓			
Ø0.363	+0.006/-0.001	0.367	✓			
0.250	+0.010/-0.000	0.248	✓			
0.625	+/-0.010	0.626	✓			
0.150	+/-0.010	0.145	✓			
R0.125	+0.010/-0.000	0.1275	✓			
1/4-28 UNF	N/A	✓	✓			

Measured by: <i>JD</i>	Audited by: <i>JML</i>	Prototype Approval:	N/A
Date: <i>07/07/19</i>	Date: <i>07/07/22</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.11.08	New Issue	KJ/JLM <i>JA</i>	<i>BE</i>

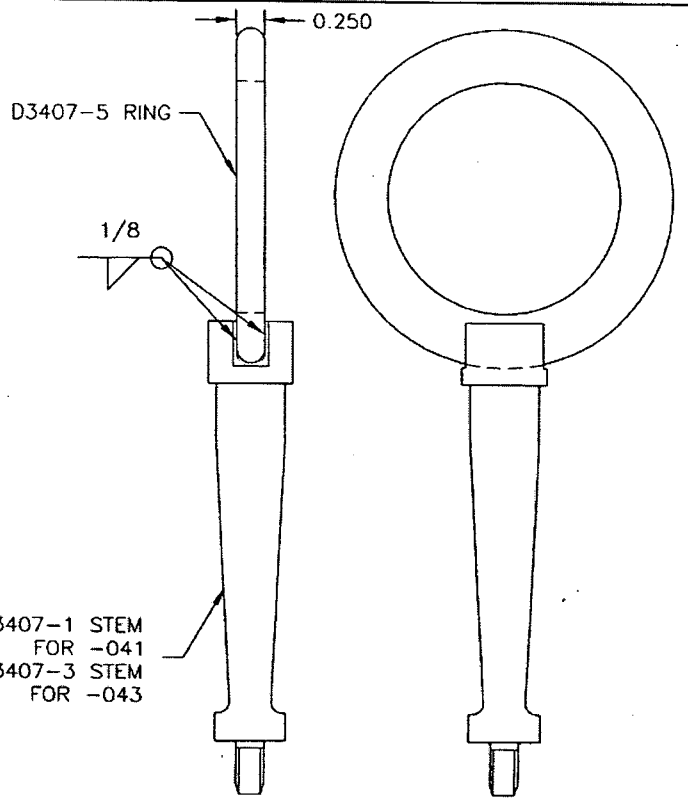


RELEASED
05 09.12

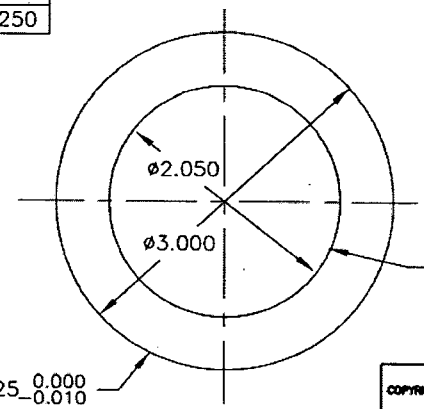


PART NUMBER	A	B	C	D
D3407-1	5.270	4.250	3.250	0.500
D3407-3	4.325	3.305	2.555	0.250

D3407-1/-3 STEM



USE D3407-1 STEM FOR -041
USE D3407-3 STEM FOR -043



D3407-5 RING

D3407-041 AND D3407-043 TOW RING:

- 11) WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
- 12) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DEBURR 0.010 TO 0.020

C	05.09.09	-1/-3 LONGER FOR FIT W/ WASHER
B	05.06.17	UPDATE DIAMETER, THREAD CLASS ADDED
A	05.03.16	NEW ISSUE
DESIGN	CP	DRAWN BY CP
CHECKED	HA	APPROVED HA
DATE	05.09.09	TOW RING
DRAWING NO.	D3407	REV. C
SHEET	1 OF 1	SCALE 1:1

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WORK ORDER NO. 32899
 WITHOUT NOTICE
 UNCONTROLLED COPY
 RETURN TO
 ENGINEERING
 SUBJECT TO AGREEMENT

D3407-1 AND D3407-3 STEM:

- 1) MATERIAL: 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R0.750)
- 2) Ø0.750 O.D.
- 3) Ø0.625 O.D.
- 4) MACHINE UNIFORM TAPER FROM Ø0.363 O.D. TO Ø0.625 O.D.
- 5) 1/4-28 UNF THREAD WITH 0.063 GRIP, CLASS 2A
- 6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 7) UNLESS OTHERWISE INDICATED
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3407-5 RING:

- 9) MATERIAL 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R3.000)
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED